

Date: Tuesday, 19/08/2008 4:04:59 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DETENT CLIP BASE
Job Number	: 41455		
Estimate Number	: 11293		
P.O. Number	:	Part Number	: D34407
This Issue	: 19/08/2008 S.O. No. :	Drawing Number	: D3440 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 41204	Material	:
Written By	:	Due Date	: 18/09/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>Jul 08-8-19</u>		
Comment	: Est. A 05.06.30 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B1500X01250	6061-T6 Bar 1.50 x 1.25
-----	--------------------	-------------------------



Comment: Qty.: 0.2035 f(s)/Unit Total: 2.0349 f(s)

6061-T6 Bar 1.5" x 1.25"

Material: 6061-T6 Bar 1.250" x 1.500"

(M6061T6B1.500x01.250)

Identify for D3440-7

Batch: M107461ml 08/08/27

(10)

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blank: 1.250" x 1.500" x 2.200" long

ml 08/08/27

(10)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA537 and Dwg D3440

Dwg Rev: A

Identify as D3440-7

Folio Rev: AAJL 08/08/29

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE.
-----	-----	-----------------------------------------



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 08/08/29

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

JS 08/08/29 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:04:59 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DETENT CLIP BASE

Job Number: 41455

Part Number: D34407

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5793

PC 579/2

(10)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/03

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-03

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 41455
Description: Detent Clip Base		Part Number: D3440-7
Inspection Dwg: D3440	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.75	+/-0.030	1.750	✓			
0.13	+/-0.030	.125	✓			
0.75	+/-0.030	.750	✓			
R0.19	+/-0.030	.19	✓			
0.50	+/-0.030	.500	✓			
0.13	+/-0.030	.125	✓			
1.470	+/-0.010	1.466	✓			
2.00	+/-0.030	2.00	✓			
R0.13	+/-0.030	.13	✓			
93°	+/-0.5°	93°	✓			
1.000	+/-0.010	1.000	✓			

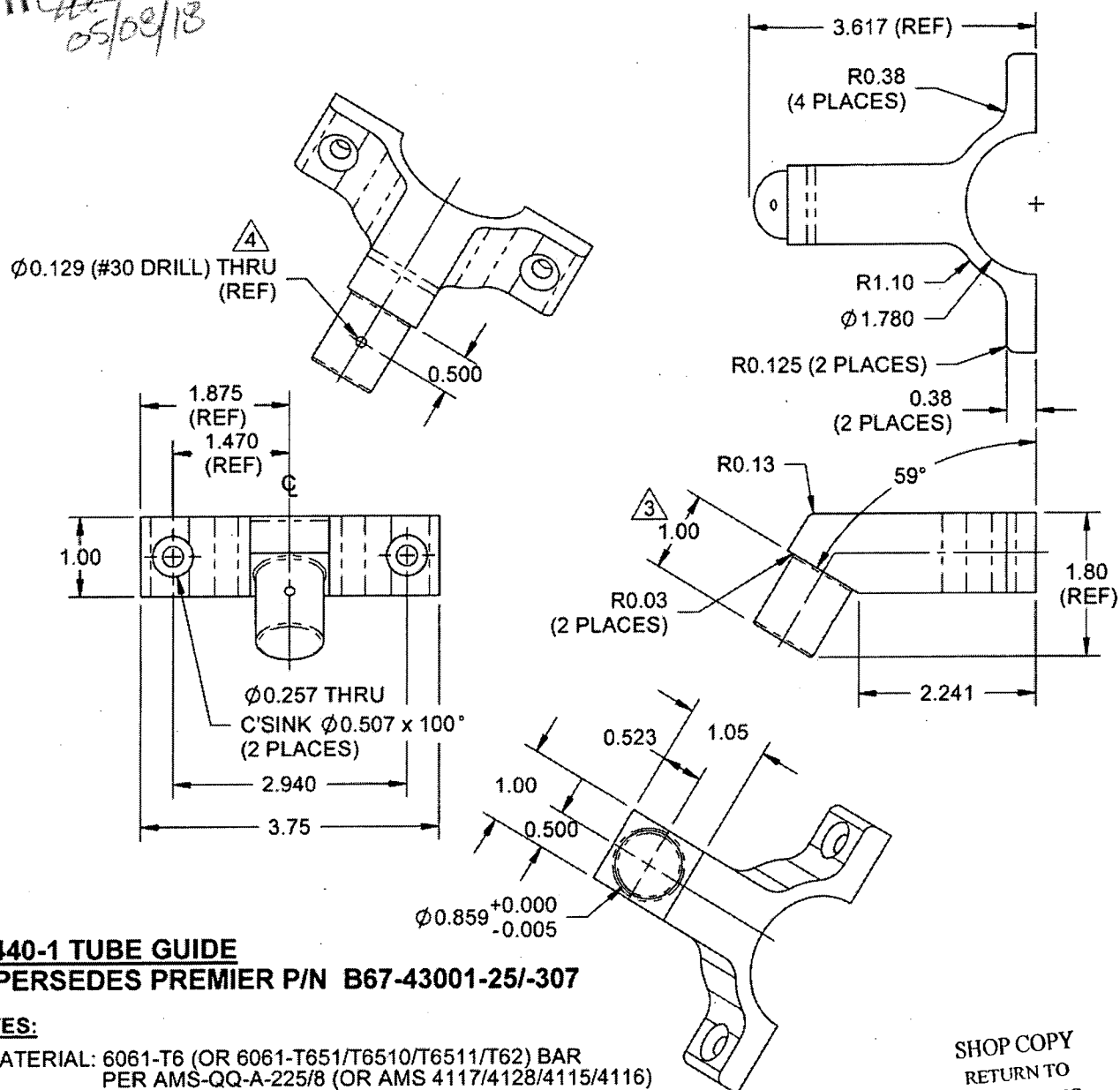
Measured by: J.L. Date: 08/08/29	Audited by: [Signature] Date: 08/08/29	Prototype Approval: Date: N/A	
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Rev	Date	Change	Revised by	Approved
A	05.09.19	New Issue	KJ/JLM [Signature]	[Signature]

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3440	REV. A SHEET 1 OF 7
DATE 05.06.02	TITLE BLADE FOLD KIT PARTS		SCALE 1:2
A	05.06.02	NEW ISSUE	

RELEASED
05/08/18



D3440-1 TUBE GUIDE
SUPERSEDES PREMIER P/N B67-43001-25/-307

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS-QQ/A/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) MASK BEFORE PAINTING.
- 4) DRILL HOLE AT ASSEMBLY.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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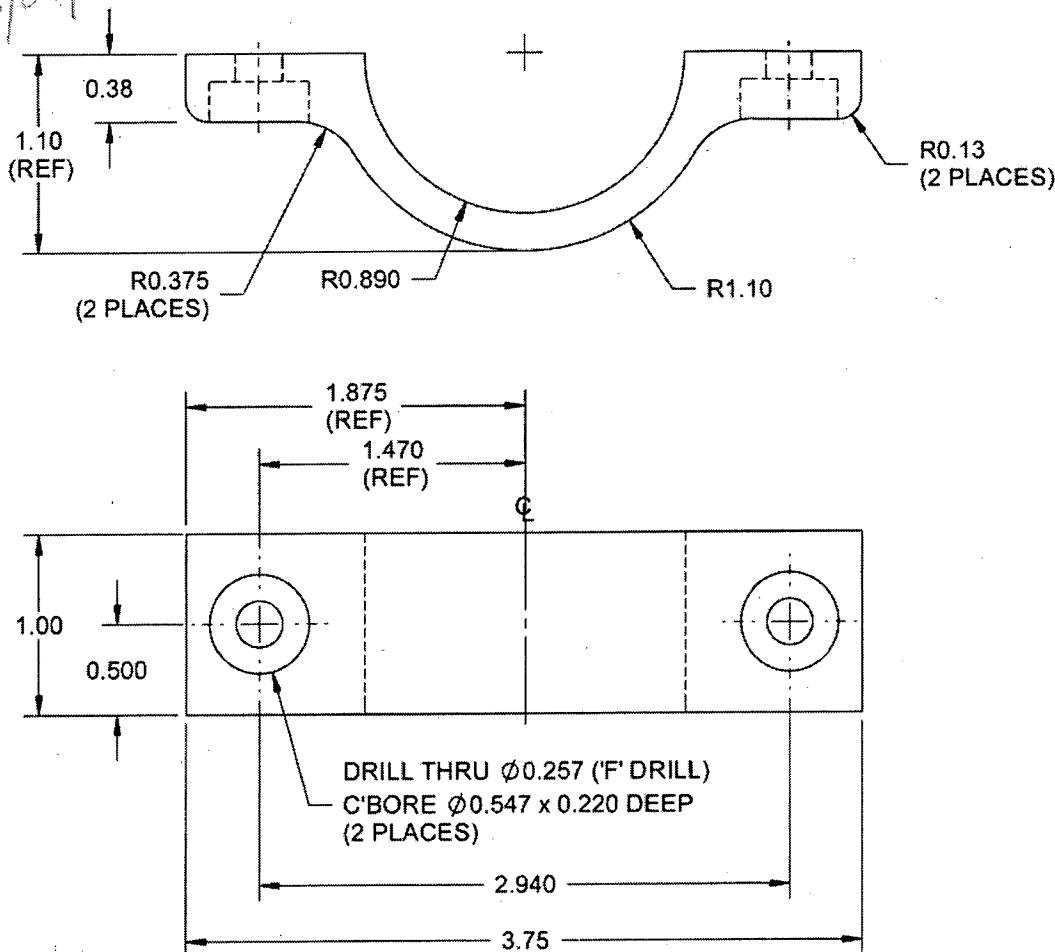
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DATE 05.06.02		TITLE BLADE FOLD KIT PARTS	SCALE 1:1

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05/08/18

**D3440-3 CLAMP****SUPERSEDES PREMIER P/N B67-43001-309****NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QQ/A/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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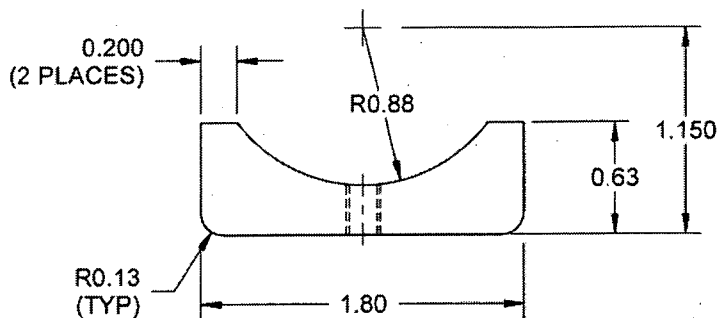
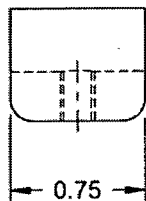
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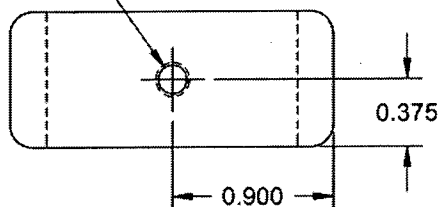


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DATE 05.06.02		TITLE BLADE FOLD KIT PARTS	SCALE 1:1

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05/08/18



DRILL $\varnothing 0.159$ THRU,
TAP #10-32 UNF THRU



D3440-5 CONTOURED DETENT CLIP BASE
SUPERSEDES PREMIER P/N B67-43001-217

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QQ/A/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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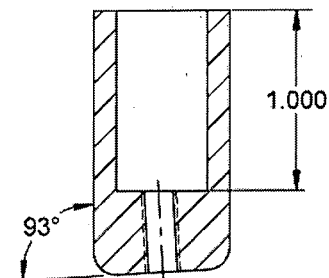
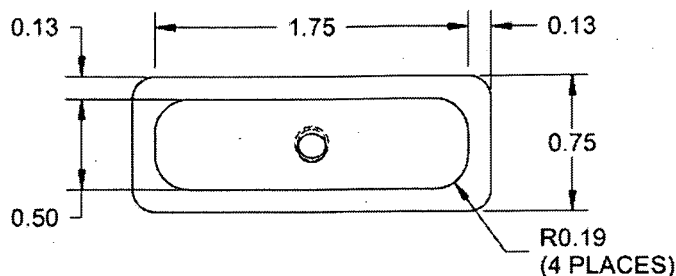
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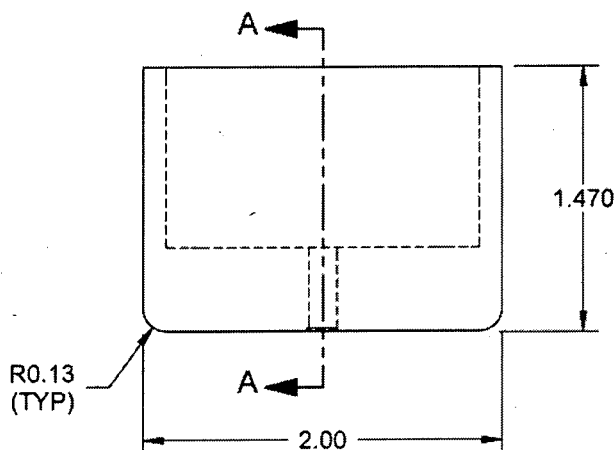
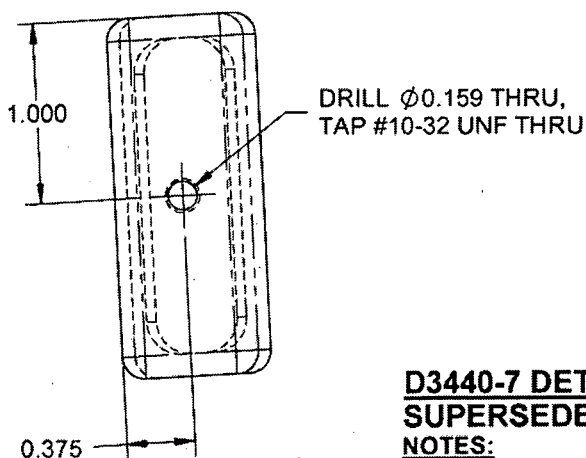


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DATE 05.06.02		TITLE BLADE FOLD KIT PARTS	SCALE 1:1

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05/03/13



SECTION A-A



D3440-7 DETENT CLIP BASE
SUPERSEDES PREMIER P/N B67-43001-221
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QQ/A/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

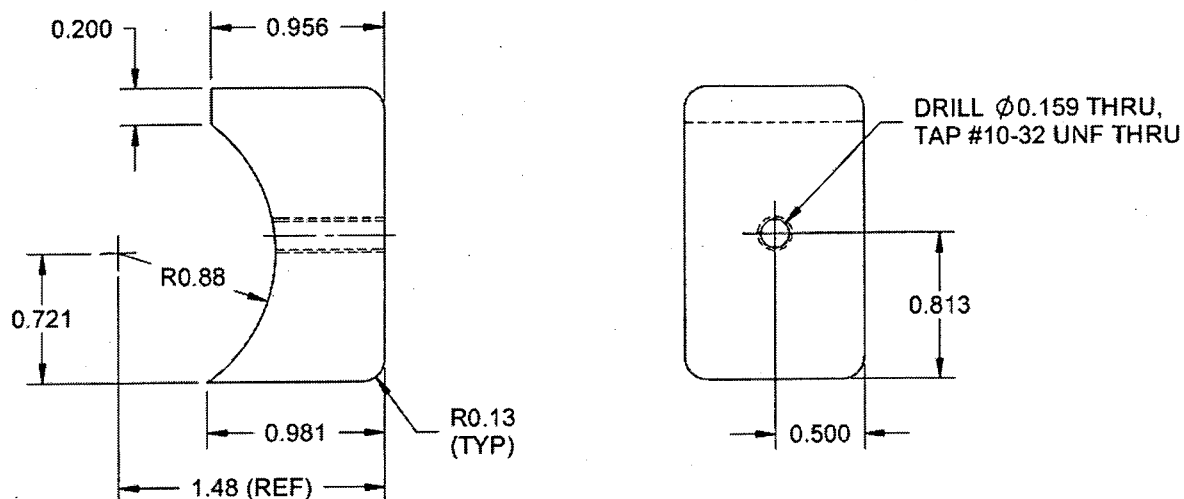
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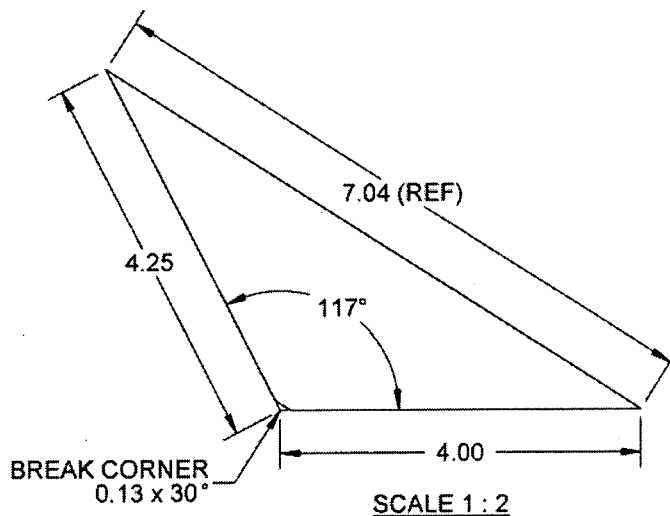
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DATE 05.06.02		TITLE BLADE FOLD KIT PARTS	SCALE 1:1



D3440-9 TUBE DETENT CLIP BASE
SUPERSEDES PREMIER P/N B67-43001-241

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QQ/A/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)

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05/08/13



D3440-11 GUSSET

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.250)

NOTES:

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

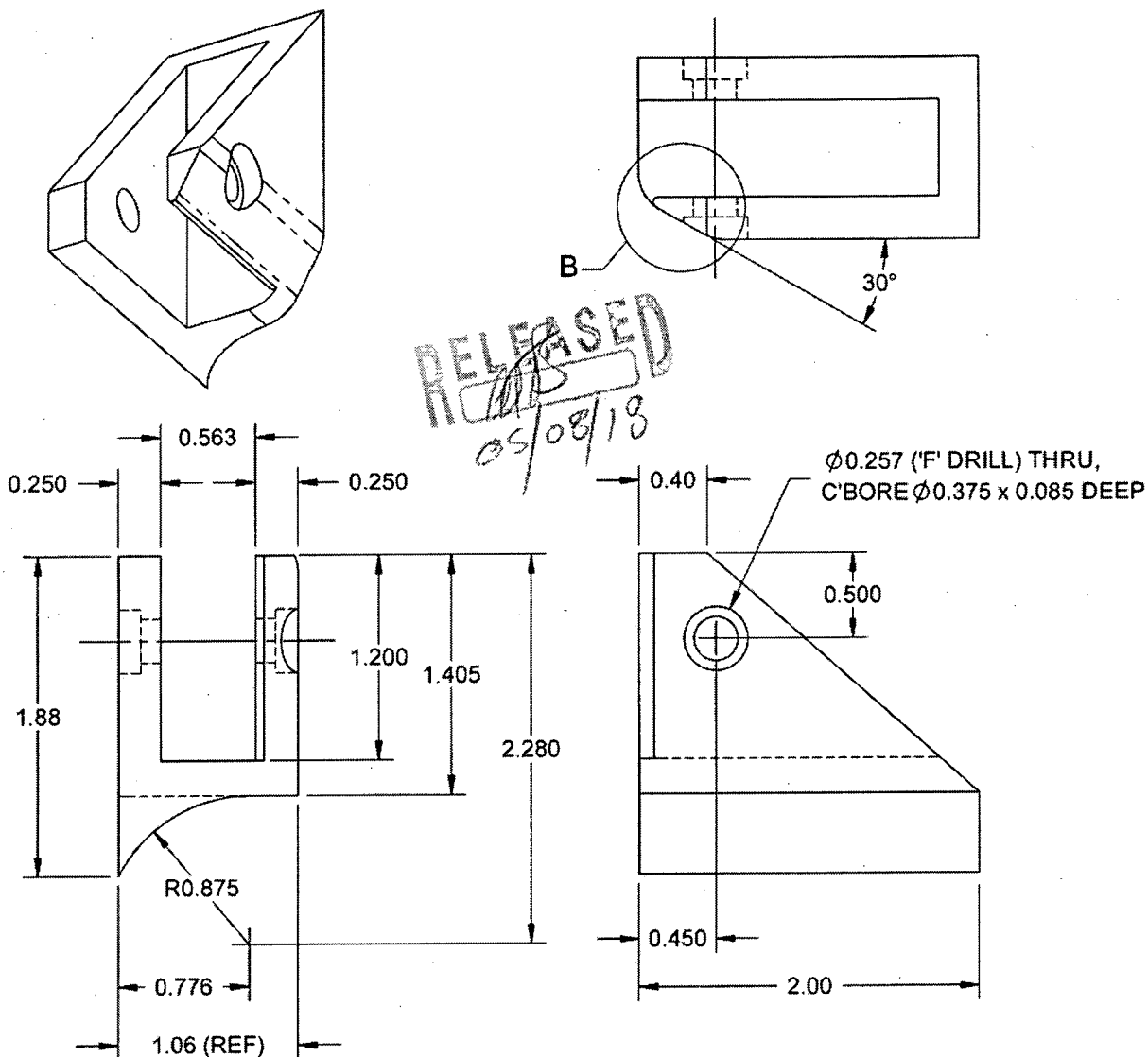
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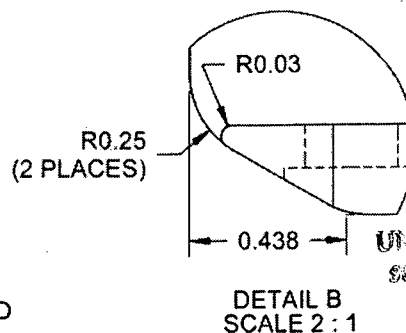
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DATE 05.06.02		TITLE BLADE FOLD KIT PARTS	SCALE 1:1



D3440-13 BRACKET
SUPERSEDES PREMIER P/N B67-43001-273

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QQ/A/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010



DETAIL B
SCALE 2:1

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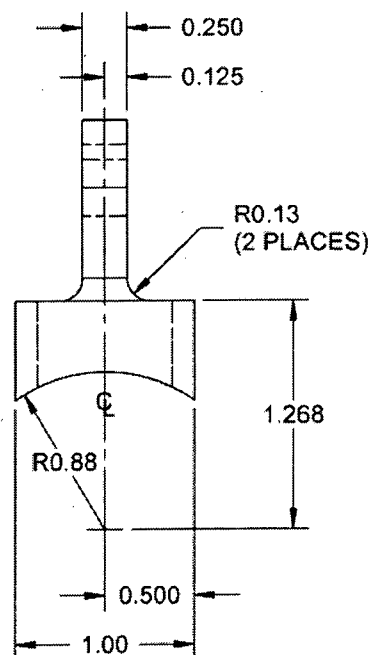
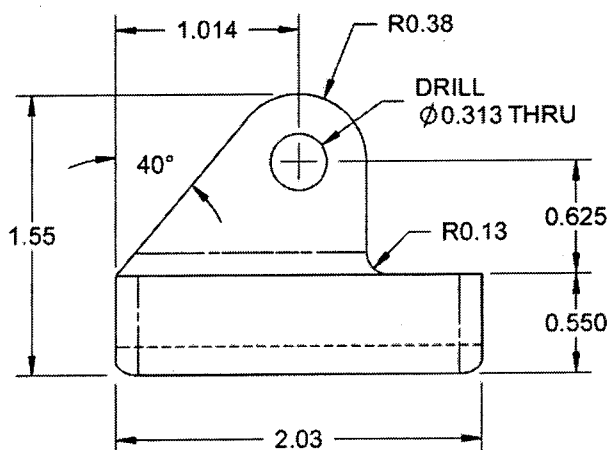
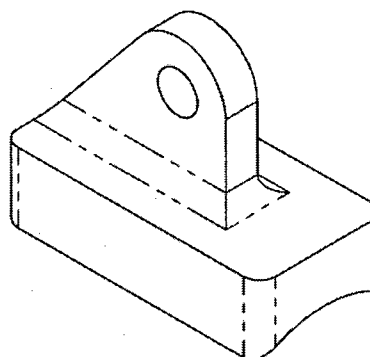
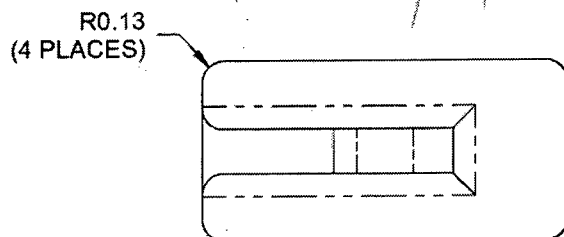
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DATE 05.06.02	TITLE BLADE FOLD KIT PARTS		SCALE 1:1

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05/08/18



D3440-15 CONTOURED MALE EYE
SUPERSEDES PREMIER P/N B67-43001-215

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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